

Date: Thursday, 11/06/2009 11:56:39 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET LID, RH)
Job Number : 48501	
Estimate Number : 13664	
P.O. Number :	Part Number : D3838042
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3838 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 48334	Material :
Written By :	Due Date : 17/06/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JUD 09-06-11</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 1.0833 f(s)/Unit Total: 2.1666 f(s)

304 SQ Tube .75x.75x.065W

batch: 1 M112051

SAP 09-06-17

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAP 09-06-17 (2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09-06-17 (2)

4.0	D37591	Bushing
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

batch: 348331 = 2x

SAP 09-06-19

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M108775

2- c/sink hole as per dwg

3- grind weld flush where indicated on dwg D3838

SAP 09-06-22 2x.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:56:39 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 48501

Part Number: D3838042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- weld D3759-1 bushing as per dwg D3838
5- grind bushing weld flush as per dwg dwg D3838
6- deburr hole if necessary

SP 09.06.22 (2x)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.22 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09.06.22 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09.06.22 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/22

Job Completion



MF 09-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

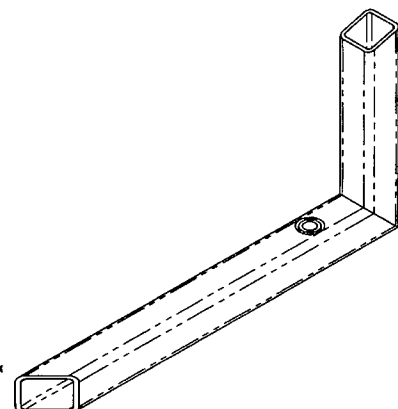
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

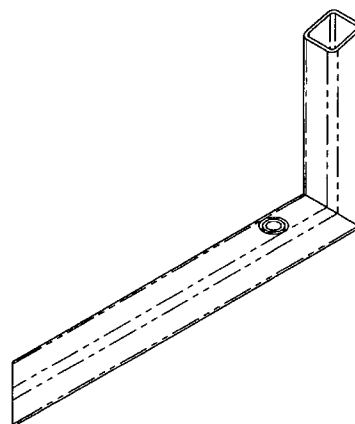
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

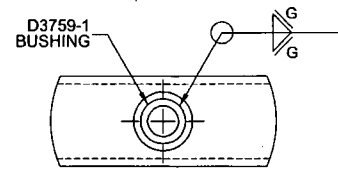
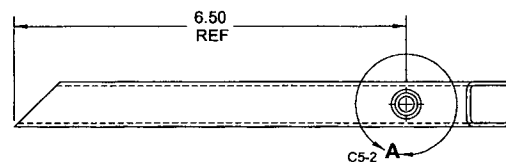
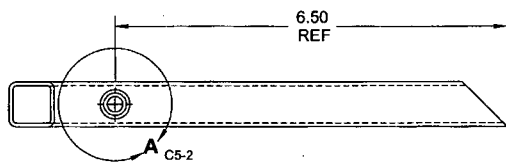
NO. 48501
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 ENGINEERING
 RETURN TO
 SHOP COPY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs

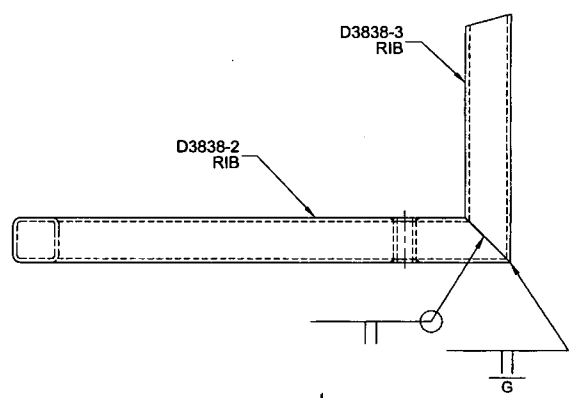
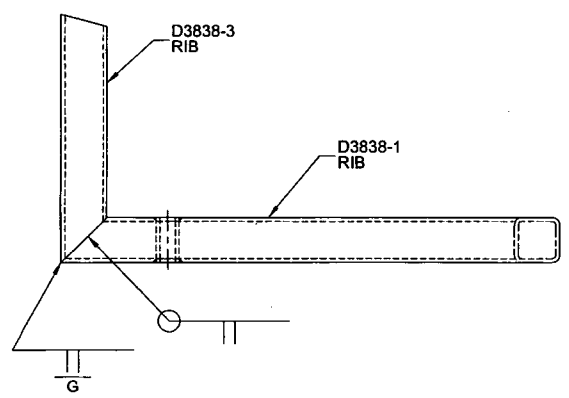
RELEASED
 08/10/08

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3838	SHEET 1 OF 3
TITLE	RIB ASSY (BASKET LID)	SCALE
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		NTS



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/10/08

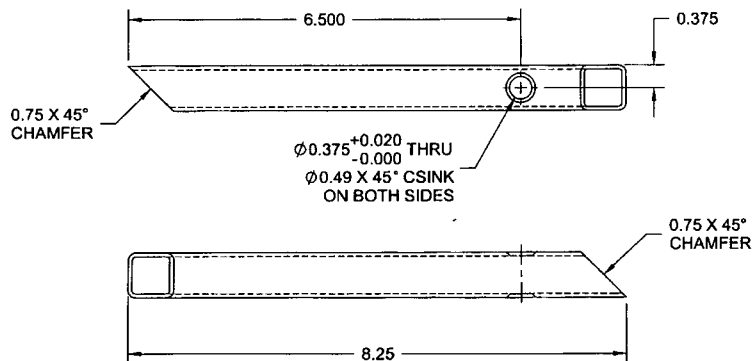
NO
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

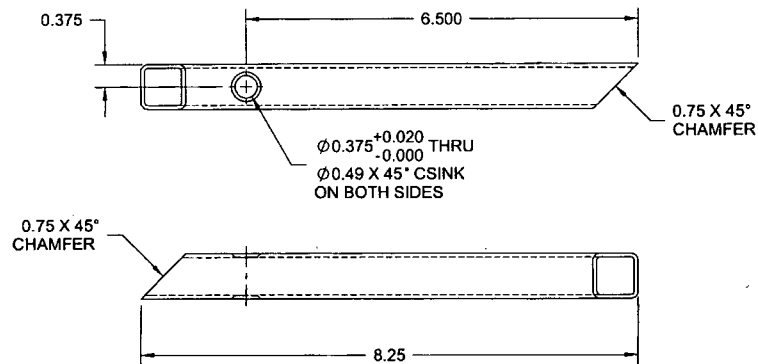
8 7 6 5 4 3 2 1

D

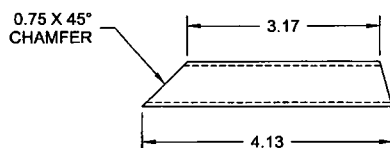
D



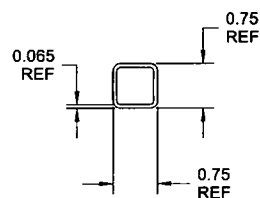
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

NO 48801
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

RELEASED
22/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

A

A